Date: Monday, 11/08/2008 2:46:44 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 41140		
Estimate Number	: 12686		
P.O. Number	:	Part Number	: D35911
This Issue	: 11/08/2008 S.O. No. :	Drawing Number	: D3591
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 31514	Material	:
Written By	:	Due Date	: 29/08/2008 Qty: 20 Um: Each
Checked & Approved By	: 𝓙𝓤𝓞 08.8.11		
Comment	: EST A 07.02.01 new issue EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.:   0.3675 f(s)/Unit   Total :   7.3500 f(s)
304 RD Tube .500 x .035W
Batch: M108250   mmƒ 08/08/21

2.0	LATHE CONV. HARDINGE .	CONVENTIONAL LATHE

Comment: CONVENTIONAL LATHE
1-Turn as per dwg D3591

2-Deburr   mmƒ 08/08/21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE   mmƒ 08/08/21

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK   08.08.25   (21)

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: BAL they   8/8/25   SV

Form: rprocess

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	**Drawing Name:** BUSHING
Job Number: 41140	**Part Number:** D35911

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

08/08/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

u 08.08.25

Form: rprocess

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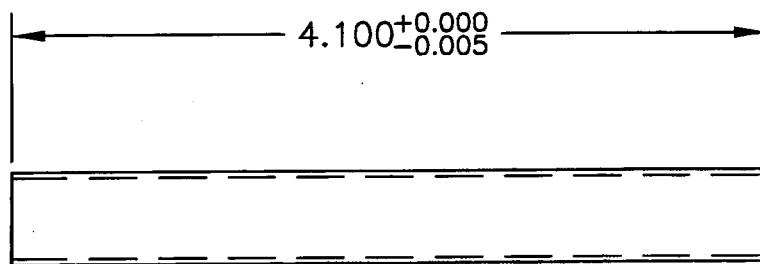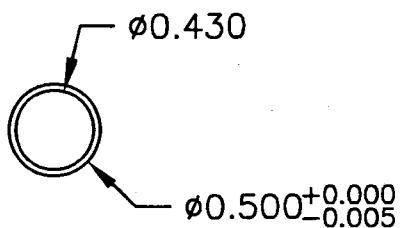| W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.100 $^{+0.000}_{-0.005}$

Ø0.430

Ø0.500 $^{+0.000}_{-0.005}$

D3591−1 BUSHING

RELEASED

07.01.30

D3591−1 BUSHING
1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
                     (REF. DART SPEC M304TR0.500W.035)
2) FINISH: NONE
3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
4) ALL DIMENSIONS ARE INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		Work Order: 41140
Description: Bushing		Part Number: D3591-1
Inspection Dwg: , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article   [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .500	+0.000 -0.005	.499	✓			
Ø .430	+0.000 -0.001	.434	✓			
4.100	+0.000 -0.005	.498	✓			

Measured by: mmc	Audited by:	Prototype Approval: N/A
Date: 08/08/21	Date: 28.08.28	Date:

Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

Part Number : D3591-1 (Bushing)

Face ~ offset/tool T0909

Extend Part ~ offset/tool T0707

Part off ~ offset/tool T111

extend part Z0.0/4.600"

Program # O3000